

Date: Wednesday, 3/14/2007 3:27:54 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 204 STEP LUG	
Job Number	: 31210		Part Number	: D23382 <i>OK TO GO</i>	
Estimate Number	: 11844		Drawing Number	: D2338 REV B <i>W/R</i>	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/14/2007 S.O. No. : N/A		Drawing Revision	: B	
Prshrt Rev.	: NC		Material	: N/A	
First Issue	: 3/14/2007 Type : MACHINED PARTS		Due Date	: 3/23/2007 Qty: 6 Um: Each	
Previous Run	:				
Written By	:				
Checked & Approved By	:				
Comment	: Est. B00.03.24 Separated -1 from -2 EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"	
		Comment: Qty.: 0.3827 f(s)/Unit Total : 2.2964 f(s) 6061-T6 Bar .50" x 6.0" Material: 6061-T6 0.5 x 6.0" Batch: <i>7103436</i> 1 blank makes one D2338-1 & one D2338-2	<i>710319</i>
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut Blanks 8.75" long	<i>710319</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2338 Tumble & Deburr	<i>710319</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<i>710320</i>
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<i>J.F. 07/03/20 ⑥</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/03/23  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 204 STEP LUG

Job Number: 31210

Part Number: D23382

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/3/22 (6)

7.0 QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/23

Job Completion



07/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**



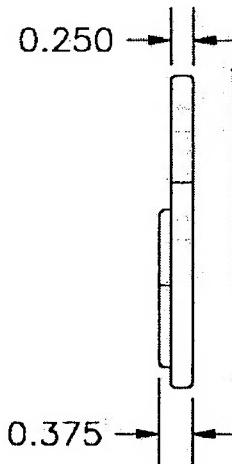
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		
B. WILLIAMS	K. HAND	APPROVED	DRAWING NO.	REV. B
CHECKED	APPROVED	R3	D2338	SHEET 1 OF 1
DATE	TITLE			SCALE
95:01:25	ENDPLATE			1:2
B	96.03.29	RE-DESIGN AND ADD D2338-2		

**RELEASED**

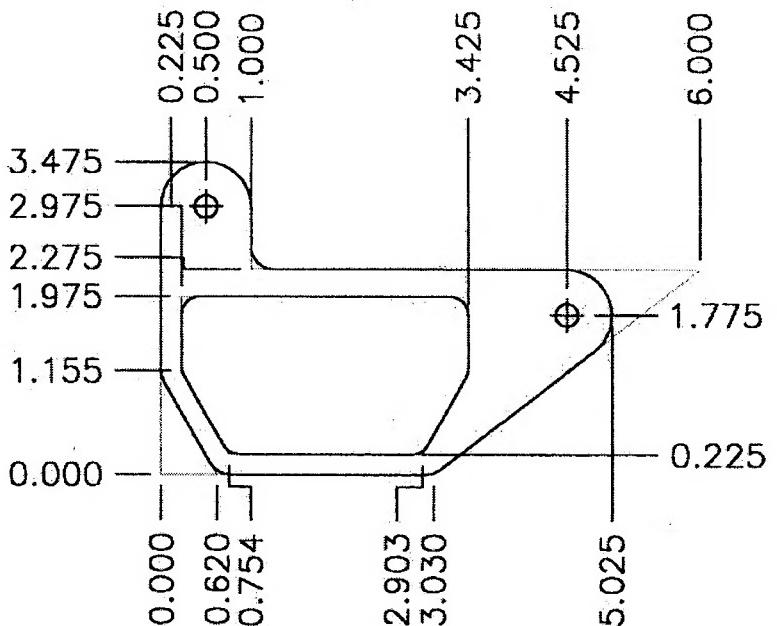
(97/04/22)

UNDER REVIEW

02. 11. 97

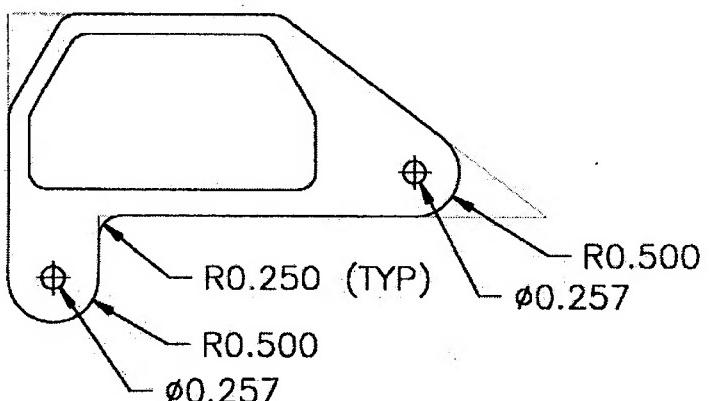


D2338-1



NOTE: BREAK ALL EDGES R0.063 MAX

D2338-2



MATERIAL: 6061-T6, 0.25 THICK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER NO.  
31210

DART AEROSPACE LTD

Work Order: 31210

Description: 204 Step Lng

Part Number: D2338-2

Inspection Dwg:

Rev:

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

 First Article     Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A						
B						
C						
D						
E						
F						
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SA  
Date: 07-03-20

Audited by: JF.  
Date: 07/03/20

Prototype Approval: N/A  
Date: N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	